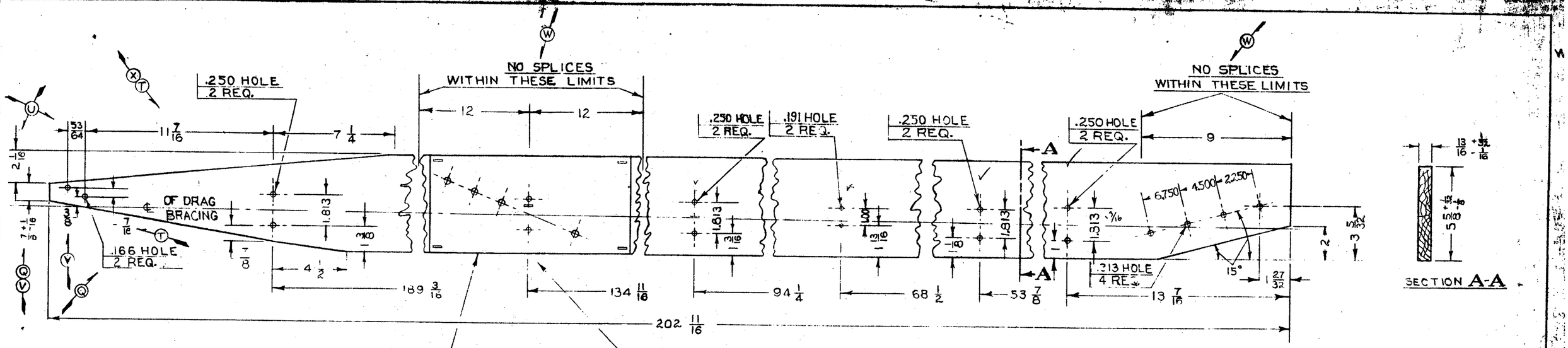
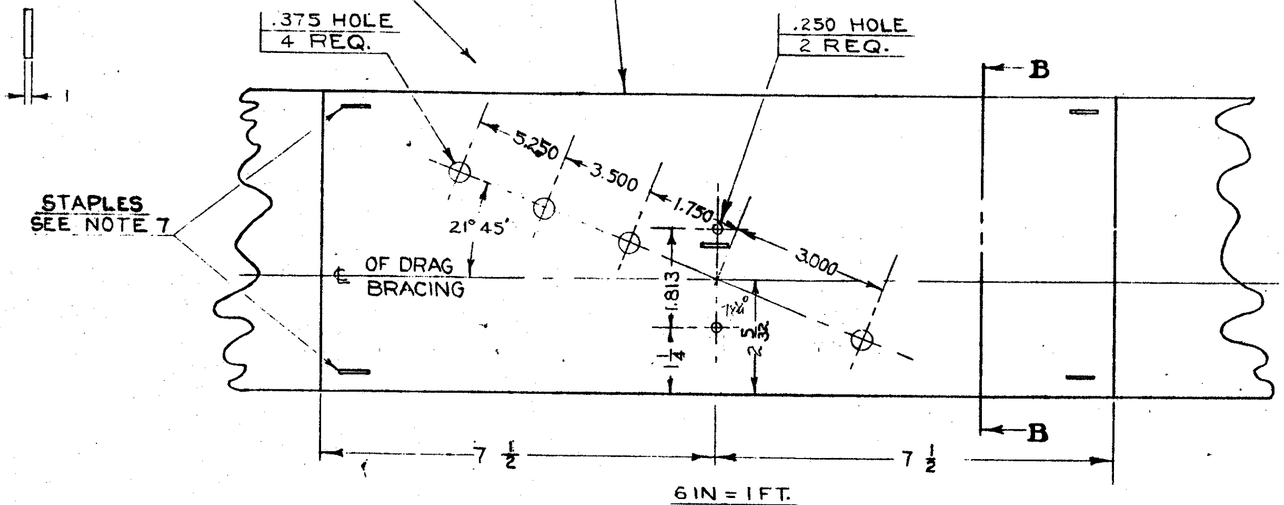


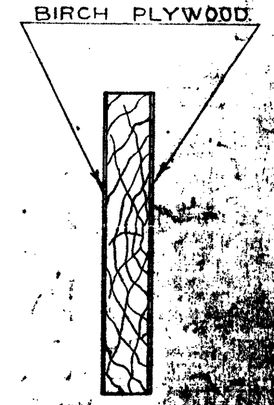
-2 SOLID SPAR BLANK (SEE DETAIL)
12142-2 DR
14653-2 DR
14663-2

-2 SPAR (BLANK DETAIL)
1 IN. = 1 FT.

-3 REINFORCEMENT



6 IN = 1 FT.



SECTION B-B

NOTES:

1. SEE DWG. 12142 OR 14653 FOR LAMINATION DETAILS.
2. SEE DWG. 15753 OR 13293 FOR MAJOR SPAR SPLICES.
3. (R) SPARS GIVEN 2 COATS OF CLEAR WOOD LACQUER BEFORE AND ONE COAT AFTER INSTALLING IN WINGS, ADDITIONAL COATS ON EDGES OF LAMINATED SPARS BEFORE ASSEMBLYING INTO WING.
4. (Y) GLUE USED MUST BE: CASEIN TYPE FEDERAL SPEC.- C-G-456 OR PHENOL TYPE RESIN GLUE #14124.
5. THE ANNUAL GROWTH LAYERS OF THE WOOD MUST MAKE AN ANGLE OF 45° OR MORE WITH THE SPAR FACE FOR AT LEAST 75% OF THE WIDTH OF EITHER VERTICAL FACE, MEASURED AT THE ENDS OF THE SPAR.
6. VERTICALLY LAMINATED SPARS SHALL BE FINISHED SO THAT THE LAMINATION THICKNESSES WILL BALANCE ABOUT THE VERTICAL CENTER-LINE OF THE CROSS SECTION WITHIN 3/32 INCH.
7. STAPLES - PLACED APPROX. AS SHOWN. MIN. EDGE DISTANCE 1/4 INCH.
8. FITTING HOLES MUST COINCIDE WITH RELATED HOLES IN MATING PARTS.
9. HOLE DIAMETER TOLERANCE +.001 -.000

PARTS MARKED THUS "△" ALSO ON 13823 (J3; L-4A).

	REVISION	DATE	BY
Z	REDRAWN WITHOUT CHANGE	10-10-44	E.L.N.
Y	NOTE 4 REVISED	6-13-44	E.L.N.
X	11 1/16 WAS 11 1/2	1-26-44	C.W.S.
W	NOTE REVISED	1-15-44	V.C.
V	7/8 ± 1/16 WAS 1 ± 1/8; 3/64 DIA. ADDED	11-25-43	C.E.K.
U	53/64 WAS 7/8; 2 1/16 WAS 2	11-25-43	C.E.K.
T	1/16 WAS 3/16; 11 1/2 WAS 11 7/16	11-25-43	C.E.K.
S	WEIGHT ADDED	11-10-43	L.A.L.
R	NOTE 2 REVISED	6-2-43	E.L.N.
Q	1 1/2 WAS 1. .125 HOLES ADDED	5-3-43	E.L.N.
P	IN 1/2 AN-H-4 WAS AN-H-14	7-13-42	C.W.S.
O	REDRAWN & REVISED	5-14-42	C.W.S.

MODEL	PER SHIP	NEXT ASSEMBLY	SUPERSEDES	SUP. BY
TG-6	2	13004		
J3	2	13004		
L-4A	2	13004		
J3	2	18004		

PIPER AIRCRAFT CORP. LOCK HAVEN, PENNA.

Δ LIMITS, SHOP PRACTICES AND FINISH, UNLESS OTHERWISE NOTED, TO BE IN ACCORDANCE WITH PIPER SPECIFICATIONS #8 AND #10.

PART No.	No. REQ.	SIZE	MATERIAL
15753	DWG. REF. ONLY	SOLID SPAR MAJOR	
13293	DWG. REF. ONLY	SPAR MAJOR SPLICE (WI	
	10	3/8 CHISEL POINT BOSTITCH	
-3	2	3/64 × 3 5/8 × 15	BIRCH PLY
14663-2 OR 12142-2 OR 14653-2	1	FRONT SPAR (BLANK)	
-2	1	1 × 5 13/16 × 203	WESTERN HEMLOCK OR SITKA SPRUCE OR PORT ORFORD CEDAR OR WEST COAST DOUG. FIR AN-F-7 OR NORWAY PINE OR YELLOW POPLAR

SCALE: 3 IN. = 1 FT. & NOTED — TOTAL WT. —
FINISH

SPAR ASSEMBLY - FRONT

DRAWN — TRACED — CHECKED — APPROVED

11233